

Date: Thursday, 12/02/2009 4:05:14 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WINDOW SEAL TOOL	<i>Rush</i>
Job Number : 45778		
Estimate Number : 12558		
P.O. Number :	Part Number : D35611	
This Issue : 12/02/2009 S.O. No. :	Drawing Number : D3561 REV.A	
Prsht Rev. : NC	Project Number : N/A	
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A	
Previous Run : 43219	Material :	
Written By :	Due Date : 12/02/2009	Qty: 12 Um: Each
Checked & Approved By :	<i>GR sooner please</i>	
Comment : Est:A 06.10.19 New issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S11GA	304/316 0.125 Sheet
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Comment: Qty.: 0.0497 sf(s)/Unit Total : 0.5960 sf(s)
304/316 .125 Sheet
Batch: *109358* *IB 9-2-13*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
1-Cut as per Dwg D3561
Dwg Rev: *A*
Prog Rev: *A*

*IB 9-2-13**16*

2-Deburr if necessary

IB 9-2-13

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE*IB 9-2-13*

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK*209-02-13* *(16)*

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

N/A

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Part Number: D35611

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3561

SB 09/02/17

(16)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09-02-18 (16)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

09/2/18 (16)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/19

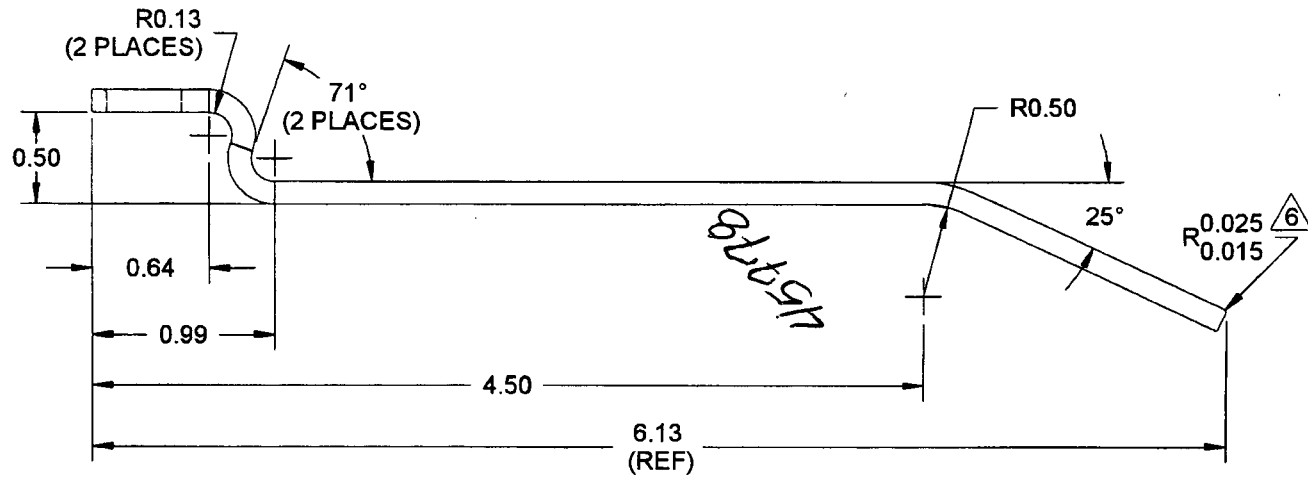
Job Completion



MF
09-02-18

DESIGN		DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		REV. A	
DATE		06.10.06		DRAWING NO. D3561	
REV.		A		SHEET 1 OF 1	
TITLE		SEAL INSERT TOOL		SCALE 1:1	
DESCRIPTION		NEW ISSUE			

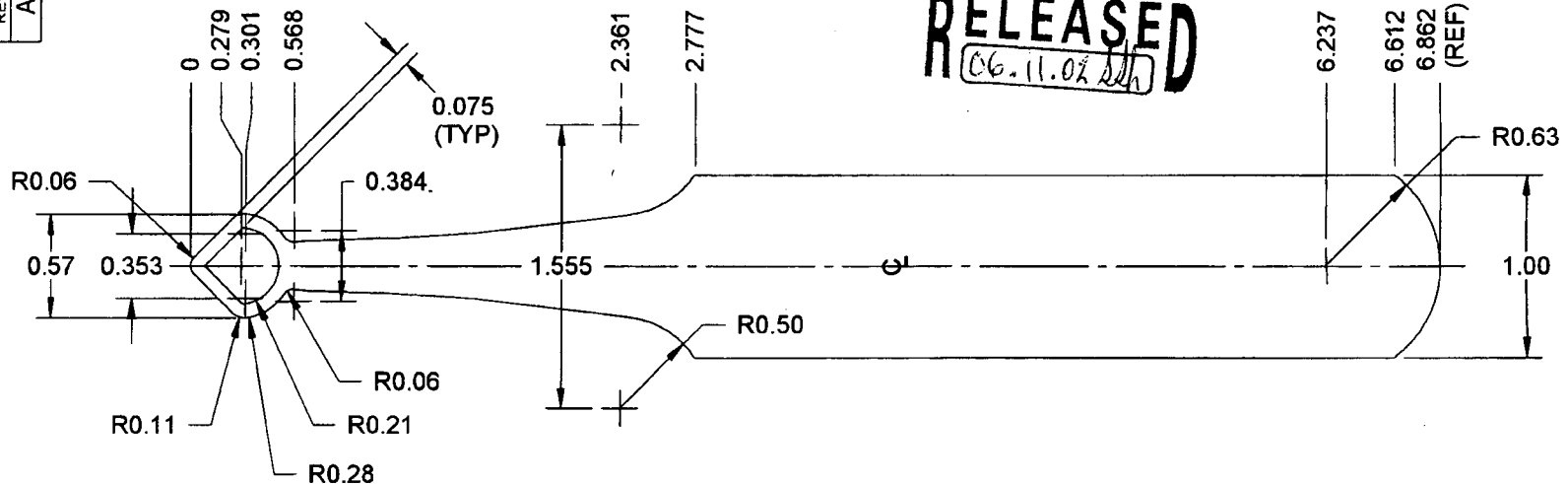
DART



D3561-1 SEAL INSERT TOOL

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.125 THICK, PER MIL-S-5059 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S10GA)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP CORNERS 0.015 TO 0.025



D3561-1F SEAL INSERT TOOL FLAT PATTERN

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